

IN THE SPECIFICATION

Please amend the paragraph beginning at page 8, line 25, to read:

The grinding processes are performed by an in-process controller in which a real dimension of the grinding portion is measured in each grinding to control the driving of the wheel slides 30a, 30b by feed-backing the measured dimension. In each grinding process, the driving of each wheel slide 30a, 30b is controlled to transmit to next grinding process at reaching to the predetermined dimension of the grinding portion. In this embodiment, the in-process controller of each grinding by grinding wheels T1, T2 is synchronous in grindings by two wheels T1 and T2 in order to transmit simultaneously to next grinding process as shown in FIG. 4. The removable amount of grinding portion by the grinding wheel T1 is ~~different~~ different from the removable amount of grinding portion by the other grinding wheel T2 in certain grinding ~~process~~ portions in order to terminate the grinding by the grinding wheel T1 prior to the termination of the grinding by the other grinding wheel T2. These relationships are explained hereinafter.